

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020700**Date Inspected:** 19-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG, Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

**Bay 14**

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 07846 from ZPMC for Bay 14. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The segment is identified as OBG. The weld designations reviewed are as follows.

SEG3007L-014, 016,  
SEG3007U-160, 167, 198, 229, 235, 241, 347

Description of Incident: During the Quality Assurance Ultrasonic Testing (UT) review of weld located on Segment 13AE, this Quality Assurance Inspector (QA) discovered one class A indication while scanning weld joint SEG3007U-160. This indication was clearly marked and recorded.

**Bay 16**

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 07846 from ZPMC for Bay 16. This QA inspector performed visual testing (VT) verification of welds after ZPMC had performed their VT inspection. The segments are identified as OBG Catwalk and Cable Tray. The weld designations

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## WELDING INSPECTION REPORT

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reviewed are as follows.

SA3430A, SA3430B, SA3430C, SA3430D, SA3431A, SA3431B, SA3431C, SA3431D, SA3431E, SA3431F, SA3432A(3), SA3432B(4), SA3432C, SA3432D, SA3432E, SA3432F, SA3433A, SA3433B, SA3433C, SA3433D, SA3433E, SA3433F, SA3433H, SA3434A, SA3434B, SA3434C, SA3434D, SA3434E, SA3434F, SA3434G, SA3435A, SA3435B, SA3435C, SA3435D, SA3435F(2), SA3441A(2), SA3441B(2), SA3441C(2), SA3441D(2), SA3441E(2), SA3443A(2), SA3443B(2), SA3443C(2), SA3443D(2), SA3436A(6), SA3436D, SA3436B(6), SA3436C, SA3438A, SA3438B, SA3439A(4), SA3439B(4), SA3440A(4), SA3440B(4).

### Blast Bay 1

This Caltrans QA Inspector and six other Caltrans QA inspectors performed a pre-blast visual inspection of the interior surface and internal components, West Tower Lift 4 subassembly, 116~131 meter mark to the bottom surface of the double diaphragm. Surface defects and base metal surface irregularities that required grinding were marked up with colored chalk, and weld defects that require welding were taped with gray masking tape for repair after the coating has been applied. ZPMC QC and ABF inspection personnel were present during the inspection and informed of QA findings.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Combs,Dennis	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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